DWG. SCALE:1 PLUT SCALE: 16:1 (C) A1658501 4 3 D D [n,Ø001,A] C Ø168 [4*2072] x .010 -.001 [.2540] SPOTFACE [-A-] Ø060 [<u>†</u>.8240] THRU [n,Ø001,A] 1. THIS IS A ULTRA-HIGH VACUUM COMPONENT (UHV). 2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL В В 3. THIS COMPONENT NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING, AND DRY NITROGEN BLOWDOWN. 4. KEEP THE PART CLEAN AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL. 5. TOLERANCE SPECIFICATIONS TO CONFORM TO TOLERANCE BLOCK. 6. ALL DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REFERENCE ONLY. A1658501 R.KRAKORA 2/94 D.SHU 5/17/94 B7 ID BEAM MIS-STEERING Α Α J.CHANG 5/16/94 T.M.KUZAY 5/18/94 SAFETY MONITOR OUTER WASHER RK JC 1/29/96 RK JC 1/29/96 01 DIM. .060 WAS .065 R.KRAKORA 2/94 DIM. .187 WAS .177 01 DIM. .020 WAS .024 RK JC 1/29/96 J.CHANG 5/16/94 01 ADDED GEOMETRIC TOLERANCES RK JC 1/29/96 16:1 SST C P4105091407-220004-01 4 3 2